

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013808**Date Inspected:** 04-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Yang and Wu Zhi Cheng	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 8BE to 8CE (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8BE to 8CE (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 from Cross Beam side towards Bike Path side. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8AW to 8BW (Root Gap and Offset)

This QA Inspector performed Joint Inspection with ABF Survey Team for the Root Gap and Offset for Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 64 and PP 65 at the following locations

Deck Panel from work point E5 to E2.

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Edge Panel from work point E2 to E1.

Side Panel from work point E1 to E3.

Bottom Panel from work point E3 to E4.

Side Panel from work point E4 to E6.

Edge Panel from work point E6 to E5.

The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 8AW to 8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045143 performing Flux Cored Arc Welding process for weld OBW8-003 located on PCMK. Deck panel splice weld between OBG segment 8AW and 8BW. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

Segment 8AW to 8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing Flux Cored Arc Welding process for weld OBW8-004 located on PCMK. Deck panel splice weld between OBG segment 8AW and 8BW. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

Segment 8AW to 8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045209 performing Flux Cored Arc Welding process for weld OBW8-002 located on PCMK. Deck panel splice weld between OBG segment 8AW and 8BW. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

Segment 8AW to 8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058087 performing Shielded Metal Arc Welding process for weld CA45-004 located on PCMK. Weld between Deck panel and edge panel (counter weight side). ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

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No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
